

Work Order ID 69931

Tuesday, May 24, 2011 2:24:15 PM



Page 1

Item ID: D3535-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 5/24/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

P

Date: 11-05-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3535	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

304.040

B11-6-1

14

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-1

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

81106102

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00				(14)			
Brake NC	Memo 1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-15	0.00							
140 QC	QC5- Inspect part completeness to step on W/O	0.00				(49)			
Quality Control	Memo	0.00							
150 Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3	0.00							
Powder Coating	Memo START TIME: 7:30 FINISH TIME: 8:00	0.00							

M115128

14x M. 11/06/06

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Page 3

Item ID: D3535-15

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Item Name: Wearshoe

Start Date: 5/24/2011 Start Qty: 12.00



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Required Date: 5/31/2011 Req'd Qty: 12.00



Customer:

Reference:

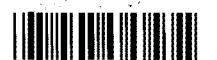
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				14		BL 11-6-6.	
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>EP-18</u> Memo	0.00 0.00				14		BL 11-6-6	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/6/7.9 ME 11-06-06	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Tuesday, May 24, 2011 2:24:22 PM

Page 1

Work Order ID: 69931



Parent Item: D3535-15



Parent Item Name: Wearshoe



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	79.8814	1.0205	12.89053	14		
											12.89053	14	

304/316 .040 Sheet

AB 11-6-1

Location

Loc Qty

Loc Code

MAT020

79.8814

116623

0.2

117550

79.6814

117550

(14)

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69931
Description: Wearshoe		Part Number:	D3535-15
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	2		V B02	
2.000	+/-0.010	2.000	2		V	
5.650	+/-0.010	5.650	2		T B01	
9.150	+/-0.010	9.150	5		T	
14.400	+/-0.010	14.400	6		T	
19.650	+/-0.010	19.650	6		T	
24.900	+/-0.010	24.900	6		T	
30.150	+/-0.010	30.150	2		T	
33.650	+/-0.010	33.650	8		T	
35.650	+/-0.010	35.650	6		T	
39.150	+/-0.010	39.150	8		T	
Ø0.188	+0.005/-0.001	.193	2		V	
24.00	+/-0.030	24.00	6		T	
16.00	+/-0.030	16.00	6		T	
8.00	+/-0.030	8.00	4		T	
5.00	+/-0.030	5.00	2		T	
0.300	+/-0.010	-303	6		V	
0.300	+/-0.010	-307	7		V	
0.038	+/-0.010	.035	X		V	

Measured by: B	Audited by: J	Prototype Approval:	N/A
Date: 11-6-1	Date: 11/6/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	B

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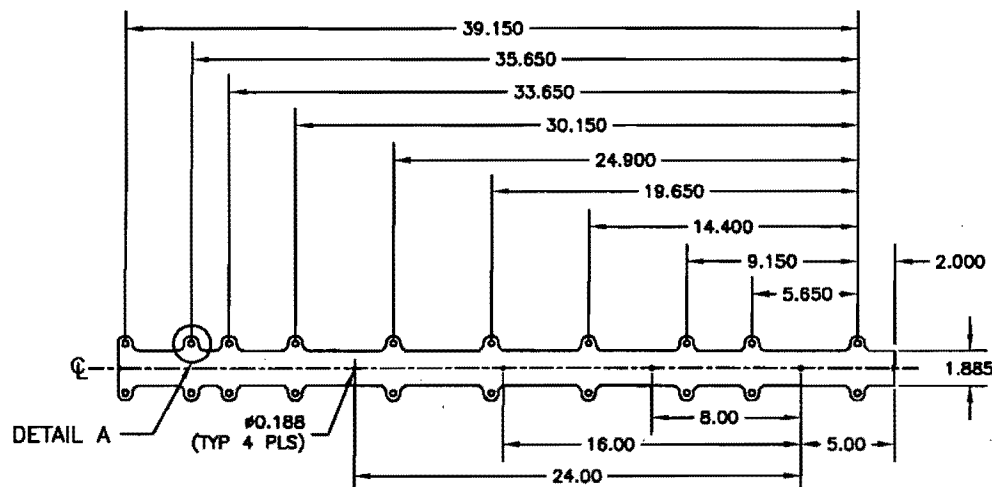


RELEASED
07.04.17

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
07.04.17		D3535
DATE	TITLE	WEARSHOE
		SCALE
		1:10
		SHEET 2 OF 7
		REV. B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69931

11-05-24

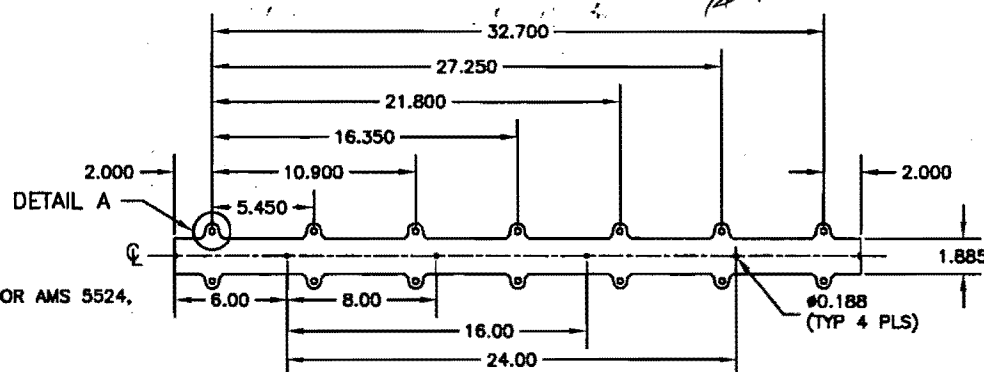


D3535-15F FLAT PATTERN

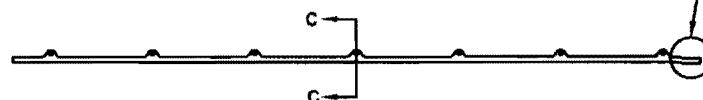
4.50 TO BEND
LINE (ON FLAT
PATTERN)

0.32
(REF)

D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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